

# Work Order ID 72071

Friday, July 22, 2011 9:58:50 AM



SHIP Aug 10th  
MAT BLACK

Page 1

Item ID: D2574

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft In 205

Stop



Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-07-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2574	Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 72071 Double check by: D.A. ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and insp

FK/af

2

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

FK/af

11/08/09

2

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FK/af

11/08/09

2

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72071**

Friday, July 22, 2011 9:58:50 AM



Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 11/08/09

Memo

0.00

2

0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

2x 0 M-14/08/09

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M115128

Memo

0.00

x2

0

M 11/08/09

START TIME: 1:00pm ☐ OVEN TEMPERATURE:  
1:30pm ☐ FINISH TIME: 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 72071**

Friday, July 22, 2011 9:58:50 AM



Page 3

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

22/08/09

170



Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

0.00

Packaging

11/8/19/20

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CK 11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 19, 2011 9:04:13 AM

Page 1

Work Order ID: 72071



Parent Item: D2574



Parent Item Name: Saddle, Aft In 205


Start Date: 7/19/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 		Manufactured	No			110	Each	3.0000	1	2			

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT046	3	
66966	3	

B71721 X2

OK 7/28/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 72071
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.440	0.440				
B	1.745	1.755		1.748	1.750				
C	3.495	3.505		3.500	3.498				
D	1.745	1.755		1.748	1.750				
E	7.990	8.010		8.003	8.003				
F	0.490	0.510		0.501	0.499				
G	0.257	0.262		0.258	0.258				
H	0.375	0.380		0.376	0.376				
I	0.490	0.510		0.500	0.500				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		0.570	0.568				
L	1.174	1.184		1.178	1.178				
M	1.365	1.375		1.368	1.369				
N	2.495	2.505		2.499	2.500				
O	4.119	4.129		4.123	4.122				
P	0.115	0.135		0.125	0.125				
Q	0.115	0.135		0.125	0.125				
R	0.240	0.260		0.251	0.251				
S	0.115	0.135		0.127	0.127				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		0.241	0.240				
W	0.115	0.135		0.126	0.118				
X	0.307	0.312		0.312	0.312				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.362	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.625	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.251	0.251				
AE	1.500	1.520		1.503	1.5095				
AF	0.115	0.135		0.125	0.125				
AG	0.240	0.280		0.250	0.250				
AH	0.240	0.260		0.251	0.251				
AI	2.000	2.020		2.002	2.002				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by:	P.K. / JRL
Date:	11/08/08

Audited by:	B.A
Date:	11/08/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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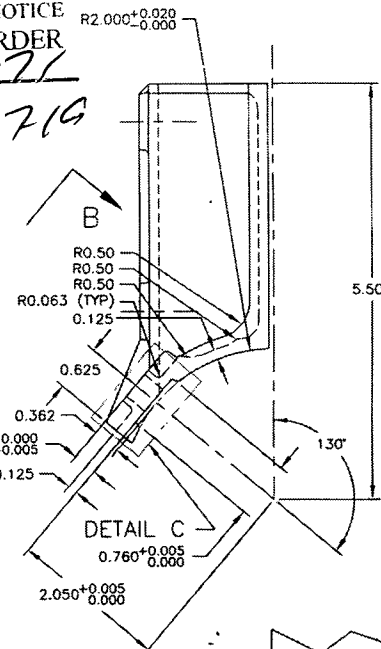
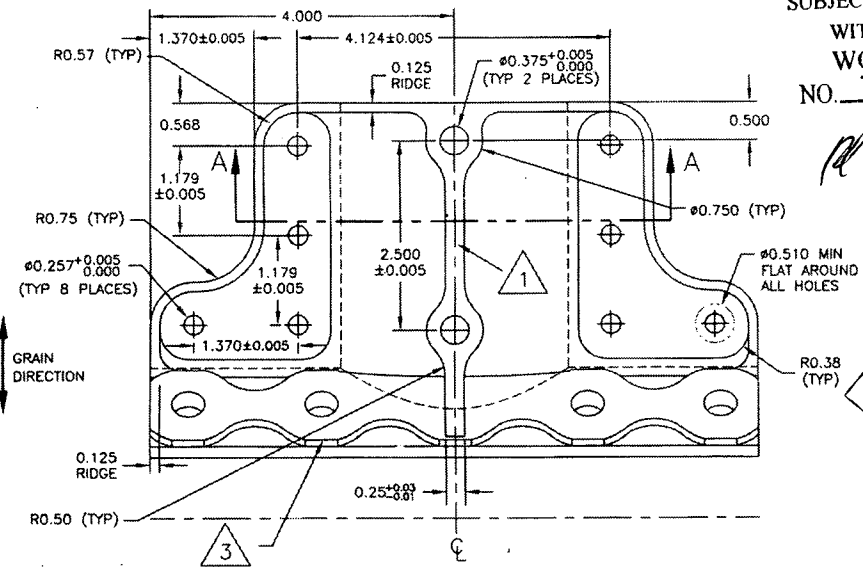
**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 72071

11-07-16

RELEASED  
05.12.06

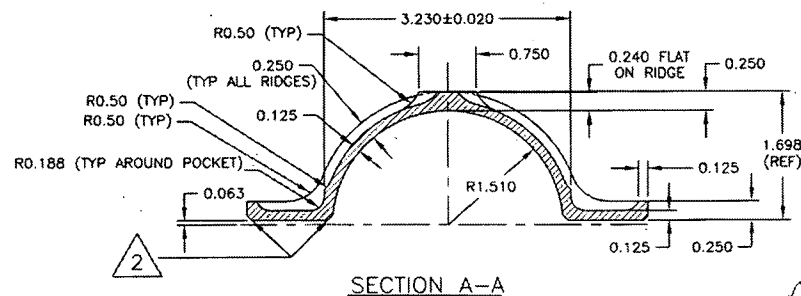


DETAIL C

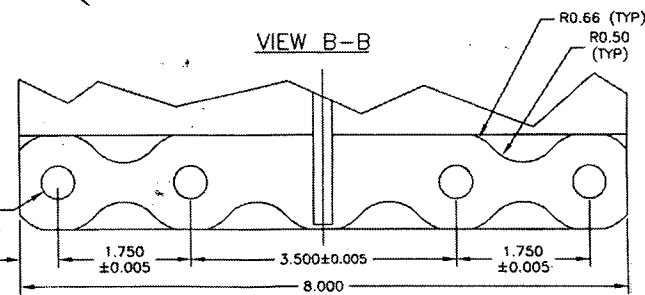
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

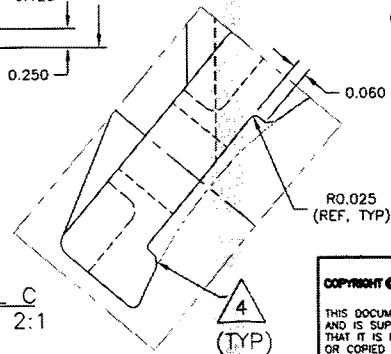


SECTION A-A



VIEW B-B

DETAIL C  
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	✓	APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE

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DART AEROSPACE LTD.

**DART** AEROSPACE LTD.  
HARRISBURG, ONTARIO, CANADA

DRAWING NO. D2574  
REV. E  
SHEET 1 OF 1  
SCALE 2:1

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